Work Order ID 53126

October 22, 2009 4:24:46 PM

Item ID: D3852-042 **Accept** **Setup Start**

Revision ID: A **Stop**

Item Name: Rib Assembly

Start Date: 10/23/2009 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/28/2009 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 09-10-22 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Draw Nbr	Revision Nbr
D3852	Rev A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Large Fab	0.00				(2)			
Large Fab									
Large Fab	**Memo**	0.00							
Large Fab	1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig□2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852□3- c'sink hole as per dwg□4- remove identification markings□5- deburr					SAD 09-10-28			
110	QC5- Inspect part completeness to step on W/O	0.00				(2)			
QC									
Quality Control	**Memo**	0.00							
						2 8 09/10/28			
120	Large Fab	0.00							
Large Fab									
Large Fab	**Memo**	0.00							
Large Fab	1- weld D3759-1 bushing as per dwg D3852 □ A/R ER316 S.S. Rod Batch: M109213 □2- grind bushing weld flush as per dwg dwg D3852□3- deburr hole if necessary								
						AD 09.11.02			

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 53126

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Revision ID: A

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Start Date: 10/23/2009 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/28/2009 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00				[illegible]	09	11	02
QC	**Memo**	0.00							
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00				(2)	0		
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: Basket	0.00				RD 09.11.02			
Packaging	**Memo**	0.00							
Packaging									

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 53126

October 22, 2009 4:24:46 PM

Item ID: D3852-042
Revision ID: A
Item Name: Rib Assembly

Start Date: 10/23/2009 **Start Qty:** 2.00
Required Date: 10/28/2009 **Req'd Qty:** 2.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00				_____	09/11/03		
Quality Control									

MF
09-11-02

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

October 22, 2009 4:24:46 PM

Work Order ID: 53126

Parent Item: D3852-042RevA

Parent Item Name: Rib Assembly

Comments:

Start Date: 10/23/2009 **Required Date:** 10/28/2009

Start Qty: 2.00 **Required Qty:** 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-3RevA1		Manufactured	No			100	Each	11.6210	0.3789	SAD	09-10-29	
Basket Hoop												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
WA	11.621		
50033	0.0527		
50618	0.5683		0.3789
51249	5		
52058	6		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1RevA		Manufactured	No			100	Each	60.0000	2.0000			
Bushing												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
WA	60		
51136	24		AD 09.11.02
51473	36		

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W/O:		WORK ORDER CHANGES					
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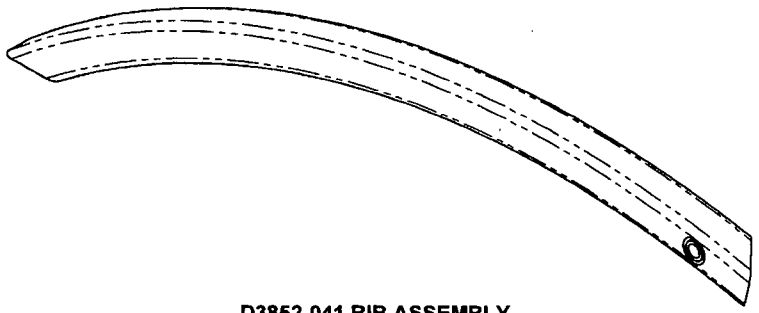
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY

#53126



D3852-042 RIB ASSEMBLY

RELEASED 08/11/18 MP

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.83 lbs EACH
8) WELDING: PER QSI 004

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	08.11.07

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.11.07

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3852 REV. A
SHEET 1 OF 3
TITLE RIB ASSEMBLY
SCALE NTS

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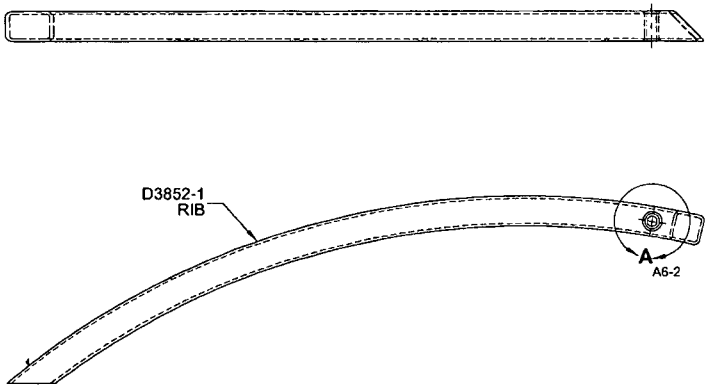
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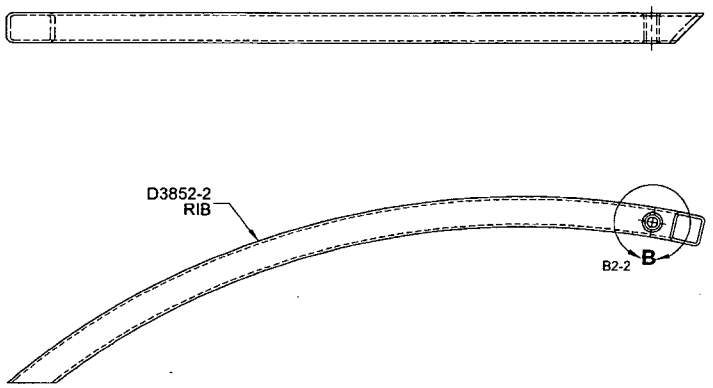
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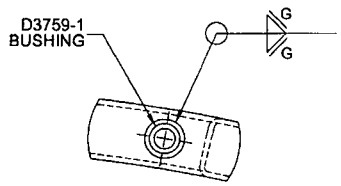


D3852-041 RIB ASSEMBLY

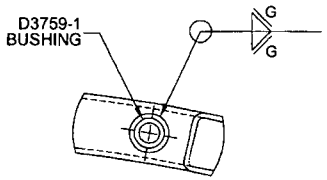


D3852-042 RIB ASSEMBLY

#53124



DETAIL A C5-2
SCALE 2X



DETAIL B C2-2
SCALE 2X

RELEASED 08/11/6/M

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3852 REV. A SHEET 2 OF 3
MFG. APPR.		
APPROVED		TITLE RIB ASSEMBLY SCALE NTS
DE APPR.		
DATE 08.11.07		

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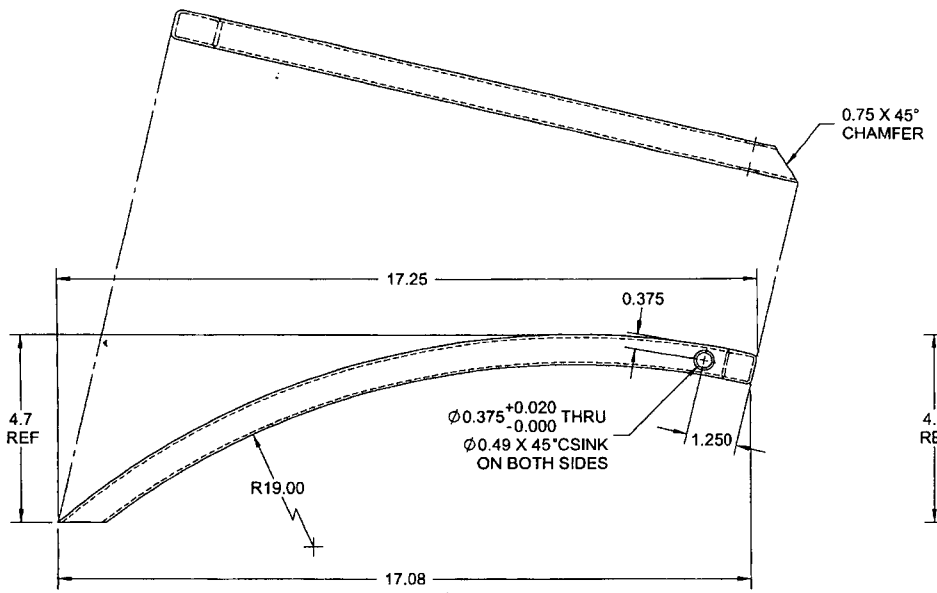
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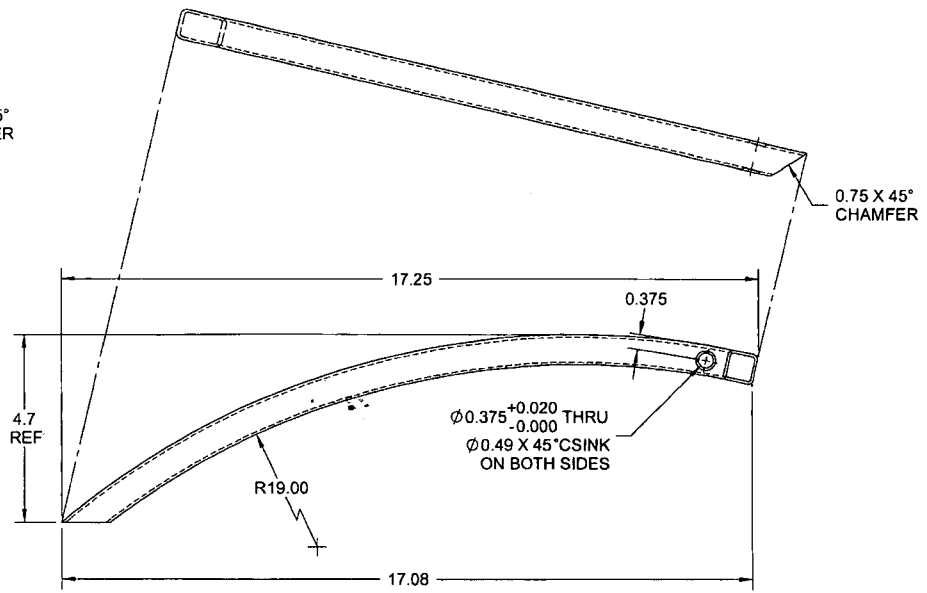
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D3852-1 RIB



D3852-2 RIB

#53126

RELEASED
05/11/8 MW

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.82 lbs EACH

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3852 REV. A
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE RIB ASSEMBLY SCALE NTS
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DATE 08.11.07		

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